

Date: Thursday, 3/23/2006 3:13:05 PM  
 User: COSS systems

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LEFT ARM WELDMENT
Job Number	: 26360		
Estimate Number	: 12106		
P.O. Number	: N/A	Part Number	: D33541
This Issue	: 3/23/2006 S.O. No. : N/A	Drawing Number	: D3354 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/30/2006
Checked & Approved By	: SEE ABOVE USER & DATE	Qty:	8 Um: Each
Comment	: est rev. A New issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140HR1000	Inventory
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Comment: Qty.: 1.0763 f(s)/Unit Total: 8.6100 f(s)

AISI 4140 ROUND BAR

Dia. 1.00" batch: M18423

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 12.30" long

AD 06.03.24. 8

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg D3354

AD 06/03/27 8

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- Mill as per dwg D3354

2-Deburr as per dwg D3354

AD 06/03/28 8

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

AD 06/03/28 8

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 06/03/13,  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:13:05 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 26360

Part Number: D33541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06-03-28 8

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 428

06/3/30

(8)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/31 (8)

Job Completion



06-03-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

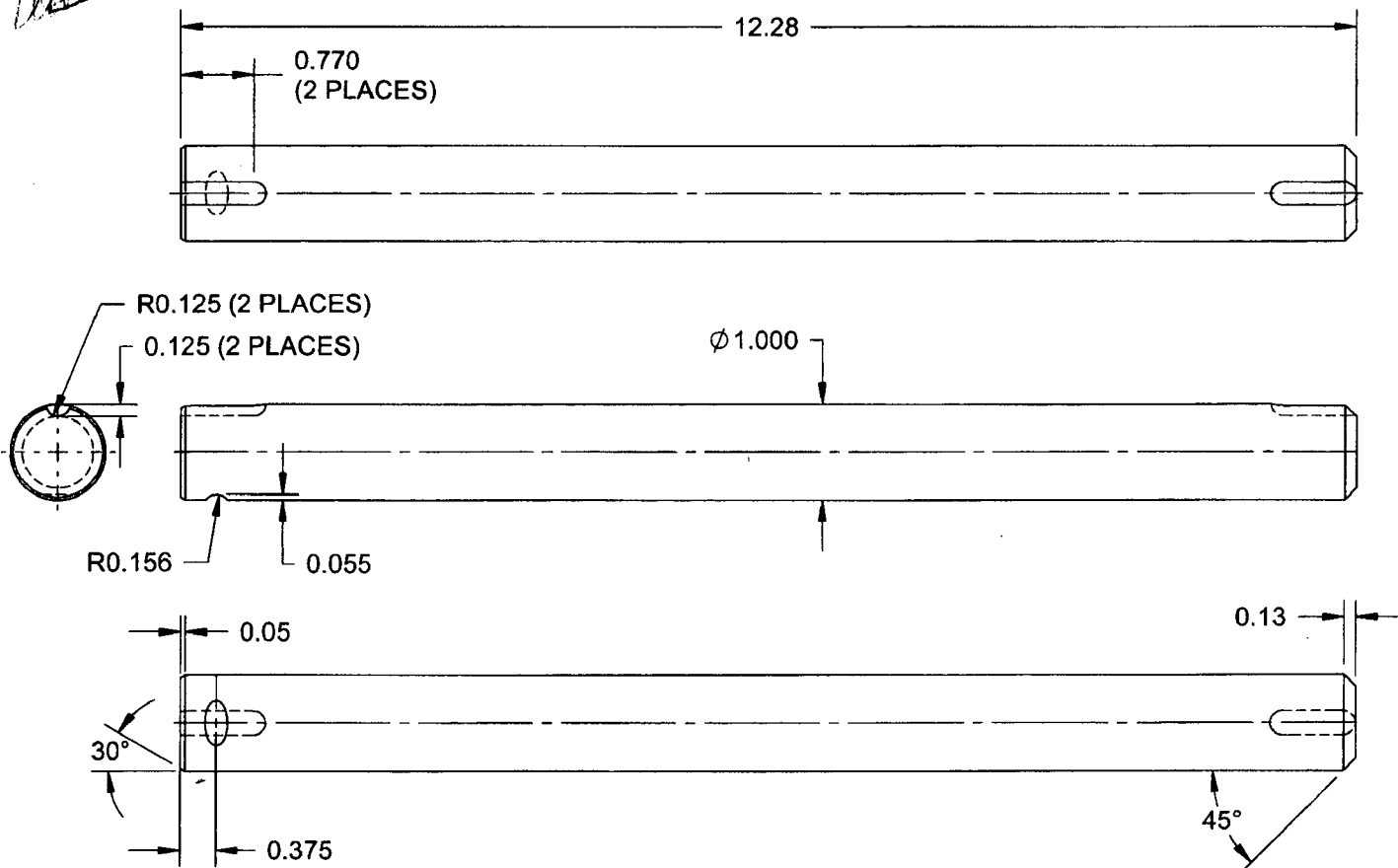
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. <b>D3354</b>	REV. A SHEET 3 OF 7
DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

**RELEASED**  
06/03/01**D3354-1 INNER SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi$  1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

PART AEROSPACE LTD Description: <i>Left Arm Weldment</i> Inspection Dwg: <i>3354</i> Rev: <i>A</i>	Work Order: <i>26360</i> Part Number: <i>D33541</i>
Page 1 of 1	

26360

Part Number:

D33541

Inspection Dwg: 3354

Rev: **A**

Page 1 of 1

☐ First Article      ☐ Prototype

## First Article

## Prototype

[illegible]

Measured  $y$ :

Da te: 06/03/28

Audited by:

Date: 06.03.28

### Prototype Approval.

Date: \_\_\_\_\_

Rev	Date	Change
1		New Issue

Revised by \_\_\_\_\_ Approved \_\_\_\_\_  
KJ/RF